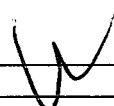
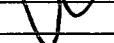


Date: Thursday, 19/04/2007 11:09:16 AM
 User: Linda Lacelle

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services	Drawing Name	: SPACEPOD FLOOR
Job Number	: 31835		
Estimate Number	: 10092		
P.O. Number	: N/A	Part Number	: D31871
This Issue	: 19/04/2007 S.O. No. : N/A	Drawing Number	: D3187 REV. B
Prsht Rev.	: NC	Project Number	: N/A
First Issue	: N/A Type : SMALL /MED FAB	Drawing Revision	: B
Previous Run	: 31835	Material	: N/A
Written By	: 	Due Date	: 30/04/2007
Checked & Approved By	: 	Qty:	20 Um: Each
Comment	: Est: C 05.04.14 Now a purchased part KJ/JLM Est Rev:D Now On Waterjet 07-04-19 JLM		

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
---------	-----------------------	---------------

1.0	M6061T6S050	6061-T6 .050 Sheet
-----	-------------	--------------------



Comment: Qty.: 7.8015 sf(s)/Unit Total: 156.0300 sf(s)

6061-T6 .050 Sheet

Batch: m104186ml 07 05 19(20)

2.0	WATER JET	FLOW WATER JET
-----	-----------	----------------



Comment: FLOW WATER JET

1-Cut as per Dwg D3187

Dwg Rev: BProg Rev: Bml 07 05 20(20)

2-Deburr if necessary

ml 07/05/30(X19)

3.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
-----	-----	--



Comment: INSPECT PARTS AS THEY COME OFF MACHINE

ml 07 05 20(20)

4.0	QC8	SECOND CHECK
-----	-----	--------------



Comment: SECOND CHECK

JAS 22(19)(PTO)

5.0	PACKAGING 1	PACKAGING RESOURCE #1
-----	-------------	-----------------------



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: St 221PC 7/6/5 (19)4.1 POWDER COAT BLACK SANDTEX4.2 QC3.ML 07/06/027/6/4 (19)

Date: Thursday, 19/04/2007 11:09:16 AM
User: Linda Lacelle

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: SPACEPOD FLOOR

Job Number: 31835

Part Number: D31871

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

QC21

FINAL INSPECTION/W/O RELEASE



(20)

Comment: FINAL INSPECTION/W/O RELEASE

PTD 10/04/07

Job Completion



U Study

(PTD) →

Date: Tuesday, 4/17/2007 11:05:13 AM
 User: Kim Johnston

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services Drawing Name : SPACEPOD FLOOR
 Job Number : 31835
 Estimate Number : 10092
 P.O. Number :
 This Issue : 4/17/2007 S.O. No. :
 Prsht Rev. : NC Part Number : D31871
 First Issue : 1 / 1 Type : PURCHASED PARTS Drawing Number : D3187 REV. B
 Previous Run : 25404 Drawing Revision : B
 Written By : Due Date : 4/30/2007 Qty: 20 Um: Each
 Checked & Approved By :
 Comment : Est: C 05.04.14 Now a purchased part KJ/JLM

Additional Product

Job Number:



Seq. #: Machine Or Operation: Description :

1.0 PG PURCHASING



Comment: PURCHASING

Issue P/O: _____
 Email or Ship DXF file to vendor
 Laser Cut flat pattern per Dwg D3187
 Possible Supplier: GFI
 Material release note is required

W. Ziegler

2.0 D31871F Spacepod Floor



Comment: Qty.: 1.0000 U(s)/Unit Total: 20.0000 U(s)
 SPACEPOD FLOOR

3.0 PACKAGING 1 PACKAGING RESOURCE #1



P-10 →

Comment: PACKAGING RESOURCE #1
 Recieve & Inspect for Transit Damage
 Ensure Material Release Note is attached

4.0 QC6 DIMENSIONAL CHECK



Comment: DIMENSIONAL CHECK

5.0 PACKAGING 1 PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1
 Identify and Stock
 Location: _____

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
070522	4.0	Took 1, to make a drill jig for the space pool floor holes, for D3187-1.	mel	07/05/22	1	<i>[Signature]</i> 070522	<i>[Signature]</i> 070522

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes ☒ No ☐ DQA: ☒ Date: 0706/04
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Tuesday, 4/17/2007 11:05:13 AM

User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: SPACEPOD FLOOR

Job Number: 31835

Part Number: D31871

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

Job Completion



W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

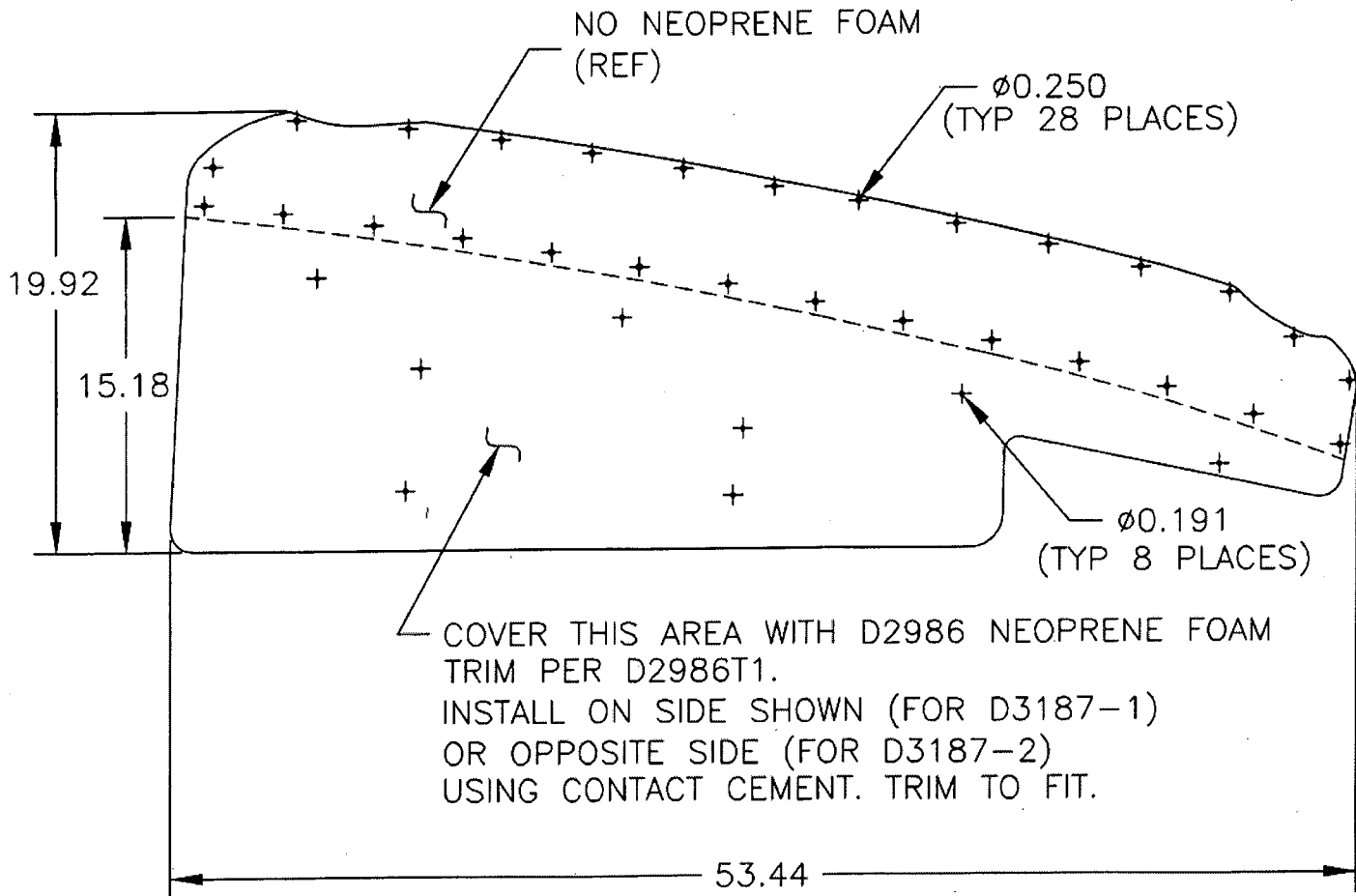
QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART

DESIGN #	DRAWN BY UP	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED #	APPROVED #	DRAWING NO. D3187	REV. B SHEET 1 OF 1
DATE 03.05.16		TITLE SPACEPOD FLOOR	SCALE NTS
A	03.03.31	NEW ISSUE	
B	03.05.16	CHANGE SHAPE	

RELEASED
03.06.25**D3187-1/-2 SPACEPOD FLOOR**

- 1) CUT/DRILL ALUMINUM PER TEMPLATE D3187-1T1
- 2) CUT NEOPRENE FOAM PER TEMPLATE D2986T1
- 2) MATERIAL: 6061-T6 (QQ-A-250/11) ALUMINUM SHEET, 0.050 THICK
(REF DART SPEC. M6061T6S.050)
- 3) FINISH: BEFORE ATTACHING NEOPRENE, POWDER COAT BLACK SANDTEX (4.3.5.7) PER DART QSI 005 4.3
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) ALL DIMENSIONS ARE IN INCHES

SHOP COPY
RETURN TO
ENGINEERING
CONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 31835

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DART AEROSPACE LTD		Work Order: 31835
Description: Scrap Space Pad Floor		Part Number: D3187-1
Inspection Dwg: D3187 Rev: B		Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

Inspection Sheet Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
A $\phi 0.250$	$\pm 0.005-0.001$	0.253	✓		VERN	
B $\phi 0.191$	$\pm 0.005-0.001$	0.193	✓		VERN	
C 19.92	± 0.030	19.92	✓		measuring tape	
D 53.44	± 0.030	53.44	✓		measuring tape	
E						
F						
G						
H						
I						
J						
K						
L						
M						
N						
O						
P						
Q						
R						
S						
T						
U						
V						
W						
X						
Y						

Measured by: ml. ml	Audited by: [Signature]	Prototype Approval:	N/A
Date: 070519	Date: 070522	Date:	N/A

Rev	Date	Change	Revised by	Approved
A	04.01.09	New Issue	KJ/RF	

[Signature]